Tuesday, 01/05/2007 2:20:43 PM

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 31869

Estimate Number P.O. Number

: 12807 A(4:

This Issue

Written By

Comment

: 01/05/2007

S.O. No. : N)

Prsht Rev. First Issue

: 31869 Previous Run

Checked & Approved By

Type

New Issue 07-02-01

: MACHINED PARTS

Project Number

Material **Due Date**

Drawing Name

Part Number

Drawing Number

: D35713

: GUIDE

: D3571 REV A

: N/A

Drawing Revision

: 13/05/2007

Each ▶ Um:

Additional Product

Job Number:



Seq. #:

Description:

6061-T6 Bar .75" X 1.5"

M6061T6B0750X01500 1.0



Comment: Qty.:

0.2531 f(s)/Unit

Total: 20.2440 f(s)

6061-T6 Bar .75" X 1.5" Batch: 14-10-107-5

07/05/02

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blank 2.90 " long

3.0

HAAS1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA681 Rev. AA& Dwg D3571 Rev. A

2-Deburr per dwg D3571



4:0

QC2



Comment: INSRE

PARTS AS THEY COME OFF MACHINE



5.0

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE C'SINK PARTS AS PER DWG D3571



Tuesday, 01/05/2007 2:20:43 PM User: Linda Lacelle **Process Sheet Drawing Name: GUIDE** Customer: CU-DAR001 Dart Helicopters Services Part Number: D35713 Job Number: 31869 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT PARTS AS THEY COME OFF MACHINE 6.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 7.0 QC8 Comment: SECOND CHECK HAND FINISHING1 HAND FINISHING RESOURCE #1 8.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING 9.0 POWDER COATING M101601 **Comment: POWDER COATING** Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 10.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 11.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: 12.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE W Daussio Job Completion

Tuesday, 4/17/2007 11:13:49 AM Date Kim Johnston **Process Sheet** : GUIDE **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 31869 : 12807 **Estimate Number** : D35713 P.O. Number **Part Number** - D3571 UNDER REVIEW : 4/17/2007 S.O. No. : **Drawing Number** This Issue : N/A : NC Project Number Prsht Rev. : U/R : MACHINED PARTS : // **Drawing Revision** First Issue Type : 31480 Material Previous Run Each : 5/12/2007 Qty: 80 Um: **Due Date** Written By Checked & Approved By : Est Rev: A New Issue 07-02-01 Comment **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 6061-T6 Bar .75" x 1.0" 1.0 M6061T6B0750X01000 20.2440 f(s) Comment: Qty.: Total: 0.2531 f(s)/Unit 6061-T6 Bar .75" X 1.0" Batch: BAND SAW 2.0 BAND SAW Comment: BAND SAW Cut blank 2.90 " long HAAS CNOVERTICAL MACHINING #1 3.0 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA681 Rev: _____ & Dwg D3571 Rev: 2-Deburr per dwg D3571 INSPECT PARTS AS THEY COME OFF MACHINE 4:0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE CONVENTIONAL MILLING MACHINE 5.0 MILLING CONV Comment: CONVENTIONAL MILLING MACHINE 1-C'SINK PARTS AS PER DWG D3571 2-Chamfer inside 1/8" slot using Dovetail cutter

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W/O:				WORK ORDER CHANGES						
DATE	STEP	PRO	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault	Category: No				Date: _ Date:		
NCR:			VORK C	RDER NON-CONFORMANC			······································	_ Date		
		Description of NC		Corrective Action Section B		Vorifi	ation	Annewal	Annroyal	
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NOTE: Date & initial all entries

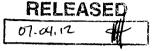
, Tuesday, 4/17/2007 11:13:49 AM Date: Kim Johnston User: 7 **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: GUIDE** Part Number: D35713 Job Number: 31869 Job Number: Description: Seq. #: Machine Or Operation: INSPECT PARTS AS THEY COME OFF MACHINE 6.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 7.0 QC8 Comment: SECOND CHECK HAND FINISHING RESOURCE #1 8.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI \$05 4.1 POWDER COATING 9.0 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 10.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 PACKAGING 1 11.0 Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: FINAL INSPECTION/W/O RELEASE 12.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

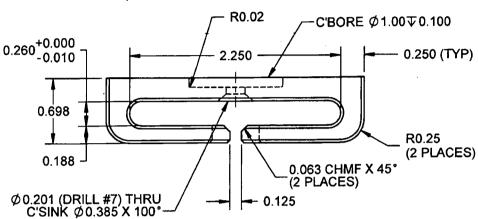
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		Description of NC		Corrective Action	Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng		otion	Sign & Date		ion C		Approval QC Inspector
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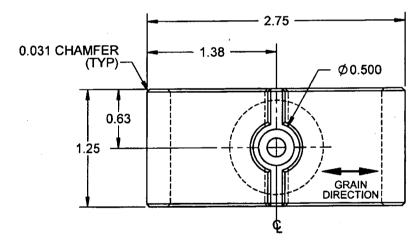
NOTE: Date & initial all entries



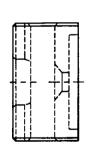
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CHECK		APPROVED	DRAWING NO.	REV. A		
1 8	H		D3571	SHEET 1 OF 2		
DATE		17,	TITLE	SCALE		
	07.0	1.29	GUIDE	1:1		
REV		DATE	DESCR	IPTION		
A		07.01.29	NEW ISSUE			







D3571-1 GUIDE



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NOTES

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B) 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

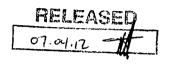
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX 7) PART IS SYMMETRIC ABOUT &

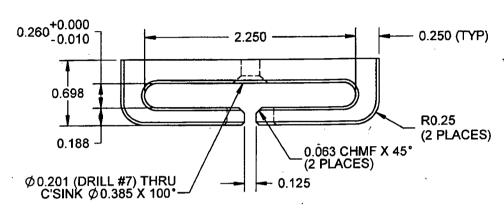
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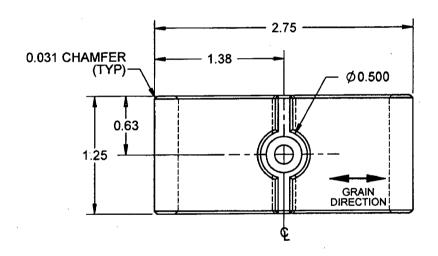
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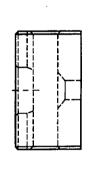


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D3571-3 GUIDE

NOTES

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "BOSTOT-STATE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

7) PART IS SYMMETRIC ABOUT &

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SUBJECT TO AMENDMENT

WITHOUT NOTICE WORK ORDER

DART AEROSPACE LTD	Work Order: 31869
Description:	Part Number: 0357/-3
Inspection Dwg: Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
,260	+ , 000	,260"	V		(+	
2. 250"	± ,010°	a 272"			./)	
, 250"	±,010'	/ 2.53"				
. 698"	± ,010"	,698'		<u>-</u>	 -	
,188"	± ,010°	.188"				
0,201"	+ .005"	g 202"				
C'SINK 9.385	" ± ,010"	Ø.390				
, /25"	±,010"	,123"	V			
.063" ×45°	±,010"	-06X450				
2,75"	±,030"	2,750				
1.38"	±,030"	1,380"				
Ø.500'	+ 1006"	0,501"				
,630	土,030"	,630°				
1, 25"	±,030"	1, 252				
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Measured by:	Audited by:	Sus	Prototype Approval:	NILA
Date: 02/05/02	Date:	OFLOSTOZ	Date:	

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	